

Monday, 07/07/2008 4:23:34 PM
Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HANDLE ASSEMBLY (EXTERIOR)
Job Number	: 40348	Part Number	: D3779041
Estimate Number	: 13371	Drawing Number	: D3779 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 07/07/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 28/07/2008
Previous Run	: 05032	Type	: SMALL / MED FAB
Written By	:	Qty:	10 Um: Each
Checked & Approved By	: <u>JUL 08.7.07</u>		
Comment	: Est Rev:A 08-06-09 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S125	6061-T6 .125 Sheet
-----	-------------	--------------------



Comment: Qty.: 0.2037 sf(s)/Unit Total : 2.0370 sf(s)

6061-T6 .125 Sheet

batch: 106634IB 8-7-14

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3779

Dwg Rev: AProg Rev: AIB 8-7-14

(14)

2-Deburr if necessary

IB 8-7-14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

IB 8-7-14

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------

COOLBY/15 (+14)

(P10) →

Comment: SECOND CHECK

COOLBY/15 (+14)

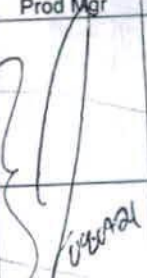

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1


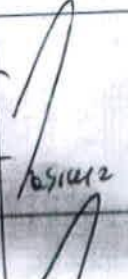
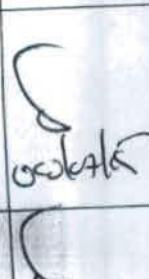
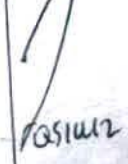
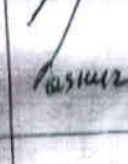
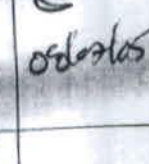
Pick Packing Kit

Dart Aerospace Ltd

Dart Aerospace Ltd			WORK ORDER CHANGES			M 08/07/21		Approval Chief Eng / Prod Mgr	Approval QC Inspector
W/O: 40348			PROCEDURE CHANGE	By	Date	Qty			
DATE	STEP		*** All perm. change ***						
08/07/21	4.1	countersink de burr		FF	08/07/23	14			
	4.2	QC 5		S	08/07/25	414			
	4.3	Chemical Conversion Coat		FL	08/07/25	148			
	4.4	QC 3		PL	08-07-28.				

Part No: D3779-041 PAR #: _____ Fault Category: Prod Eng Coordinating NCR: (Yes) No DQA: _____ Date: _____
QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR: 40348-2		Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/07/21	40	During QCR inspection it was found that the distance between the 0.315" holes is 6.960" measured 7.000"		update draw water Jet AND Program according to Draw. Removal <u>Removal</u>	08/07/25	08/07/25		
				Ensure Employee verifies measurement. Holes are 0.040" off	8-7-15	08/07/25		
		QC Program on water Jet was not updated to the Draw 08779-1. Operator took Program from Prelim		Scratch and Destroy and replace QCR 1.14 Bt m 66634	8-7-15	08/07/25		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY (EXTERIOR)

Job Number: 40348

Part Number: D3779041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D32031

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Handle

batch: 40353

Resh/28 (11)

7.0

MS20426AD10 18

Rivet Countersunk



Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)

Rivet Countersunk

batch: M107736 417

or (MS20426AD10-10)

B

D3779-41
3 stock

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Mos/07/21

1- counter sink holes as per dwg D3779

2- deburr

3- rivet D3203-1 handle to D3779-1 plate as per dwg D3779 per QSI003

FF 08/10/06

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/06

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: _____

Resh/28 (11)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/06

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.10.06

ART AEROSPACE LTD

Work Order:	40349
-------------	-------

Description: HANDLE ASS'y (EXTERIOR)

Part Number:	D 3779-1
--------------	----------

Inspection Dwg: D.3779-1 Rev: A


Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

[illegible]

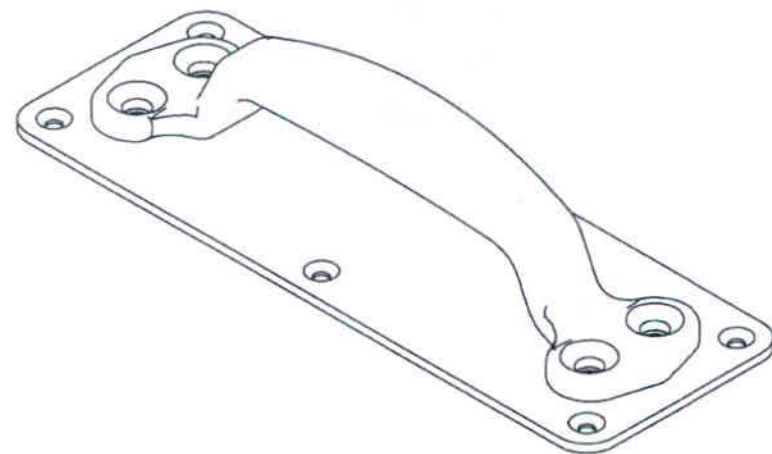
Measured by:	HB
Date:	8-7-15

Audited by:	
Date:	08/07/15

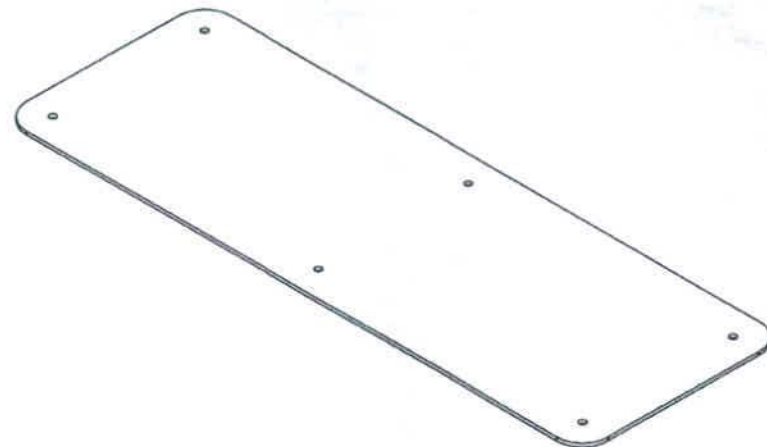
Prototype Approval:	A	
Date:		4

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

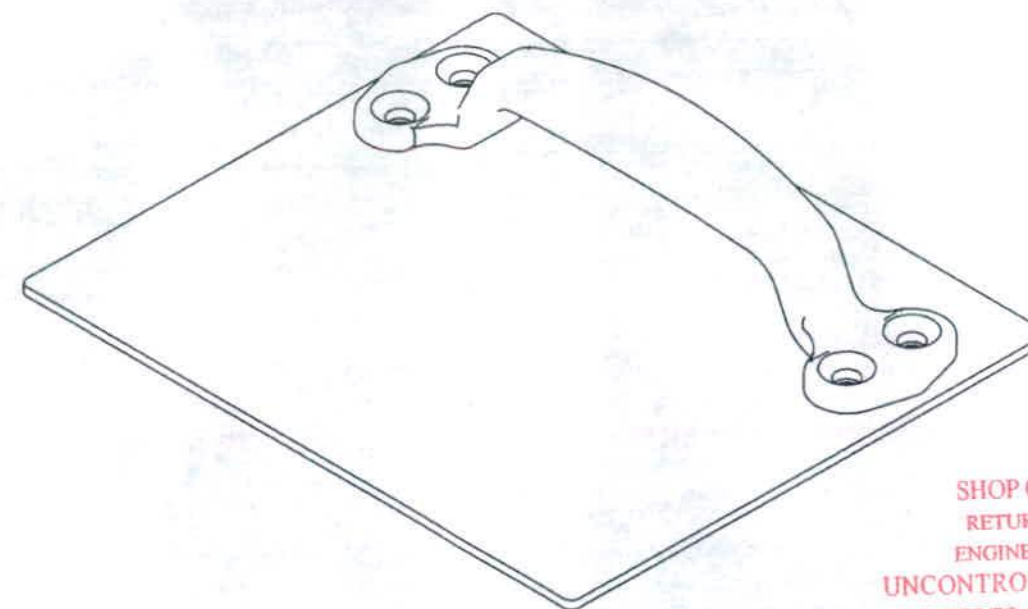
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426AD10-8	RIVET, CSK



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)



D3779-3 DOUBLER PLATE

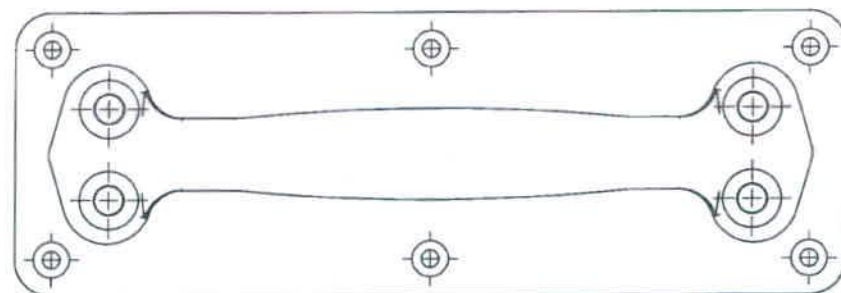


D3779-043 HANDLE ASSEMBLY
(INTERIOR)

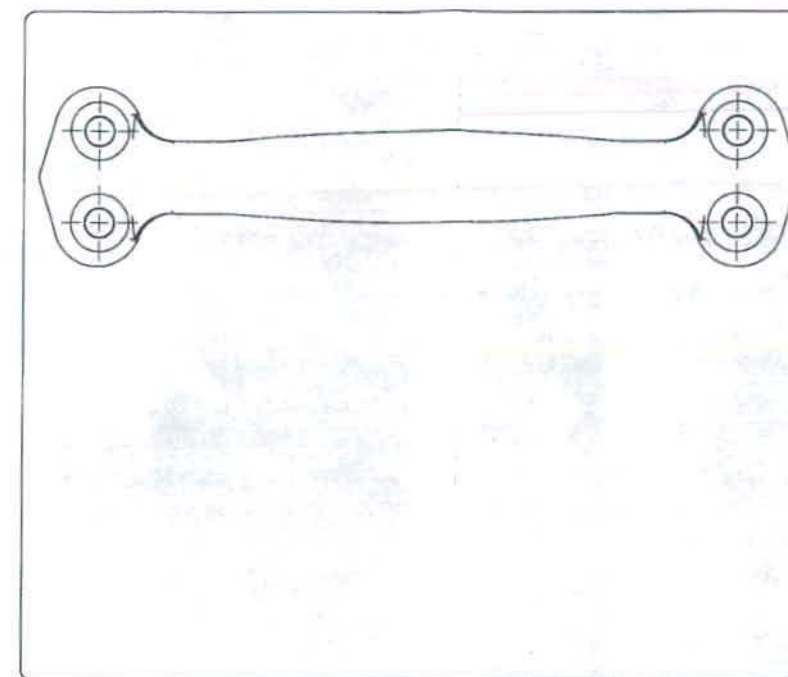
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

RELEASED
08-06-26 MJD

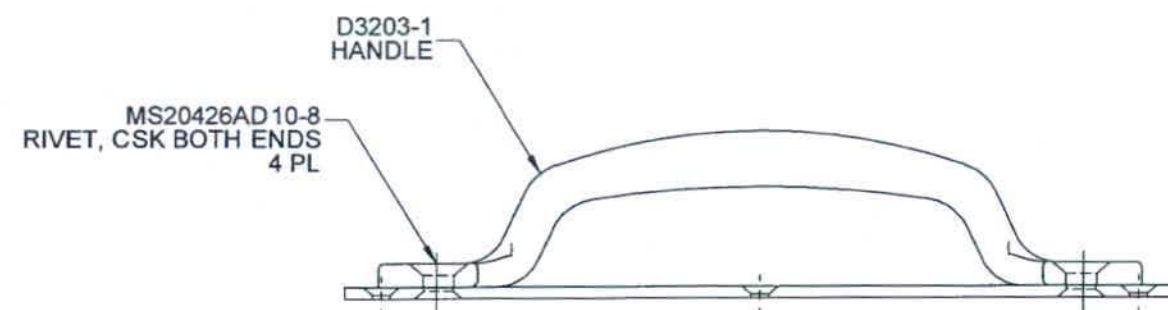
A	NEW ISSUE	AJS	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
DATE	08.04.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



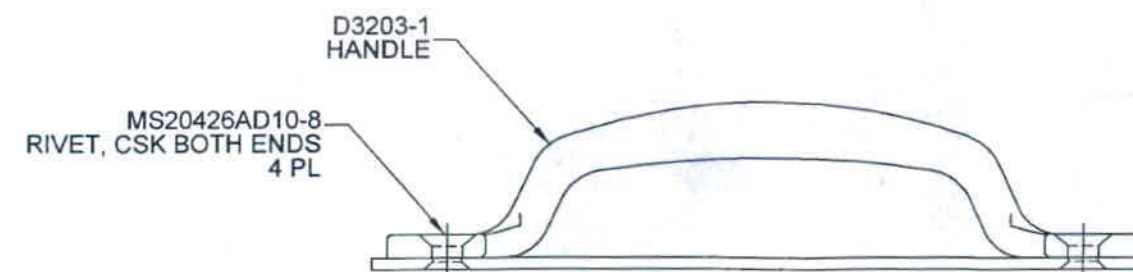
D3779-1
PLATE



D3779-5
PLATE



D3779-041 HANDLE ASSEMBLY
(EXTERIOR)



D3779-043 HANDLE ASSEMBLY
(INTERIOR)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.71 lbs APPROX (-041)
- 9) WEIGHT: 1.14 lbs APPROX (-043)

RELEASED
08-06-26 1/18

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40329-2

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
DATE	08.04.21	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

